

Work Order ID 129984

129984

Page 1

February-23-15 10:36:01 AM

Item ID: D4462-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Baffle
 Start Date: 2/23/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1502-26 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4462	E								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg Prog rev: <u>E</u> Dwg rev: <u>E</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

4 0 JM15-3-10

4 0 JM15-3-10

(4) DAS 38 9-89 MAR 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

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 Item Name: Baffle
 Start Date: 2/23/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 4.00 *4* Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

4 38 9-89 MAR 27 2015

4X Dh 15/3/30

MLJ 1503-30

MS 3-30

DQA: _____ Date: _____



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Picklist Print

February-23-15 10:36:01 AM

Page 1

Work Order ID: 129984

129984

Parent Item: D4462-1

D4462-1

Parent Item Name: Baffle

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC IPP REV:B
13.10.28 DWG REV PD1 DD VERF:JLM IPP REV:C 14.06.13
AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

252.1162

~~9.263158~~

M6061T6S 063

(16)

Jm15-3-10

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

252.1162

M128941

11.132

M129845

30.0743

M130096

25

M130745

24.0799

M131322

86.83

M131383

75

~~131653~~

131653

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DART AEROSPACE LTD		Work Order: 129984
Description: Baffle		Part Number: D4462-1
Inspection Dwg: D4462	Rev: E	Page 1 of 1

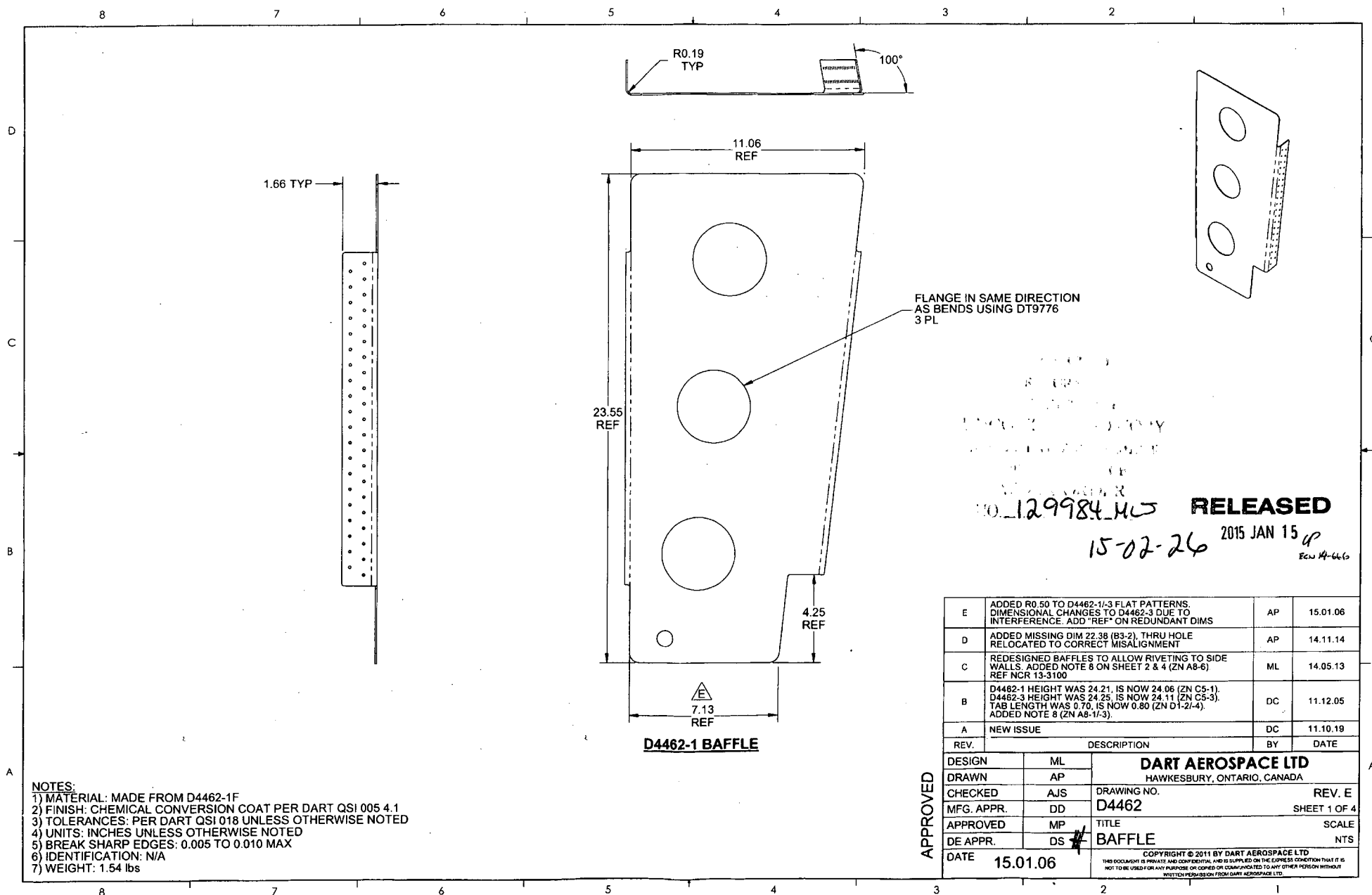
INSPECTION SHEET

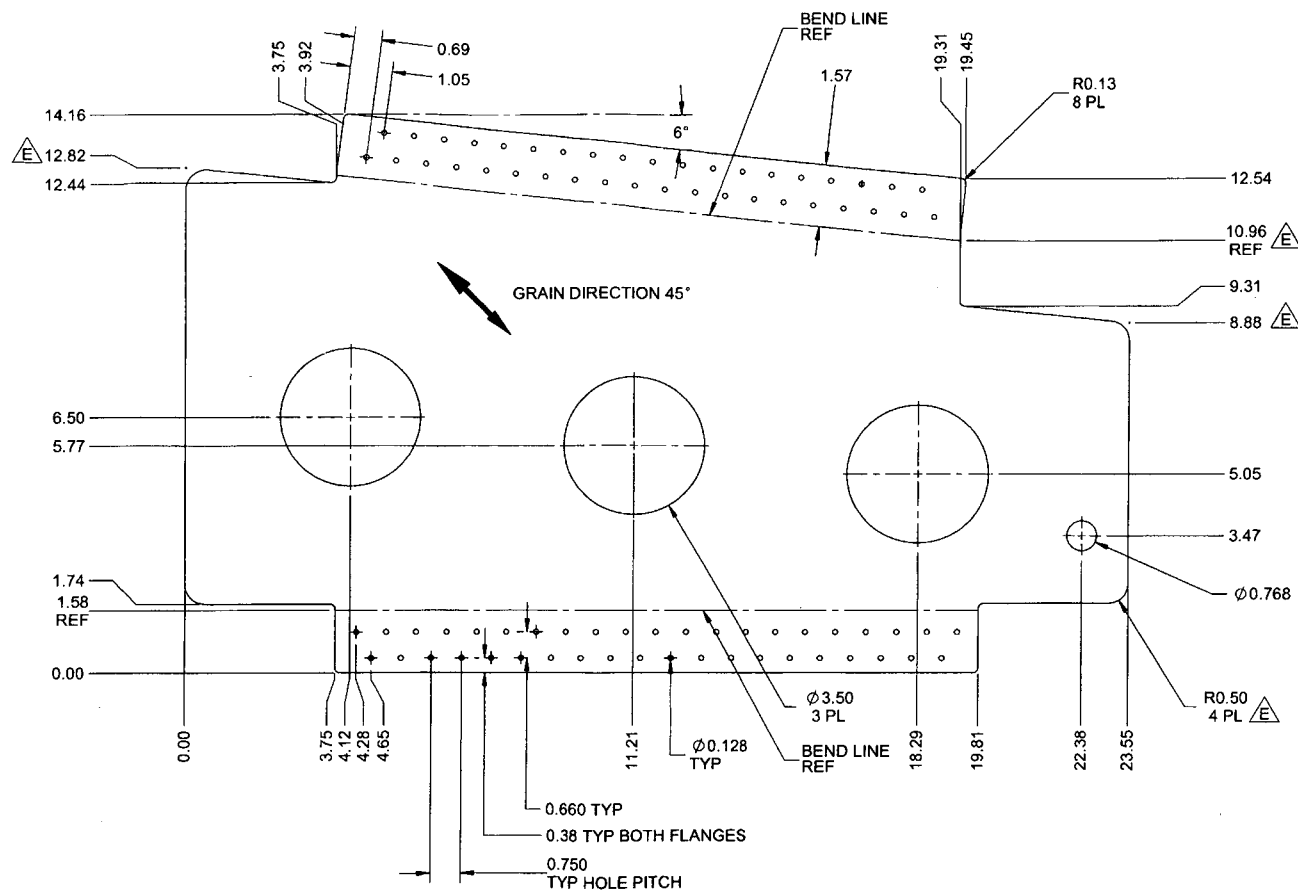
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.129"	-		V	Jemo1
Ø0.768	+0.010/-0.001	0.768"	-		V	
Ø3.50	+0.012/-0.001	3.502"	-		V	
0.660	+/-0.010	0.664"	-		V	
0.38	+/-0.030	0.382"	-		V	
0.750	+/-0.010	0.754"	-		V	
1.74	+/-0.030	1.74"	-		V	
5.77	+/-0.030	5.77"	-		V	
6.50	+/-0.030	6.50"	-		V	
12.44	+/-0.030	12.44"	-		T	Jemo7
14.16	+/-0.030	14.16"	-		T	
3.75	+/-0.030	3.75"	-		V	
4.12	+/-0.030	4.12"	-		V	
4.28	+/-0.030	4.28"	-		V	
4.65	+/-0.030	4.65"	-		V	
11.21	+/-0.030	11.21"	-		T	
18.29	+/-0.030	18.29"	-		T	
19.81	+/-0.030	19.81"	-		T	
22.38	+/-0.030	22.38"	-		T	
23.55	+/-0.030	23.55"	-		T	
5.05	+/-0.030	5.05"	-		V	
9.31	+/-0.030	9.31"	-		T	
12.54	+/-0.030	12.54"	-		T	

Measured by: Jm	Checked by: 38	QC Inspector:
Date: 15-3-10	Date: MAR 13 15	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	
C	13.05.08	Dwg Rev updated	KJ	
D	15.01.14	Dimensions updated per Dwg Rev C	KJ	
E	15.01.20	Dimensions updated per Dwg Rev E	KJ	





D4462-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.54 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4462-1F-E.DXF"

RELEASED

2015 JAN 15

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DD	D4462	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BAFFLE	NTS
DATE	15.01.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

